

Date: Monday, 07/07/2008 8:36:18 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FRONT INBOARD LEG		
Job Number	: 40312		Part Number	: D37681		
Estimate Number	: 13375		Drawing Number	: D3768~.REVA		
P.O. Number	:		Project Number	: N/A		
This Issue	: 07/07/2008	S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: SMALL /MED FAB			
Previous Run	:		Due Date	: 30/07/2008	Qty:	2
Written By	:		Um:	Each		
Checked & Approved By	: <u>JUL 08 7.07</u>					
Comment	: Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6T1000W065	6061T6 TUBE 
		Comment: Qty.: 0.8969 f(s)/Unit Total : 1.7938 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M108380</u>
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to lenght as per dwg D3768 2-drill holes thru on both ends of tube as per dwg D3768 3-deburr
3.0	QC5	INSPECT WORK TO CURRENT STEP 
		Comment: INSPECT WORK TO CURRENT STEP
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
5.0	POWDER COATING	POWDER COATING 
		Comment: POWDER COATING Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 8:00AM11 08-07-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 8:36:19 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT INBOARD LEG

Job Number: 40312

Part Number: D37681

Job Number:



Seq. #: Machine Or Operation:

Description :

OVEN TEMPERATURE: 320° F

FINISH TIME: 8:30AM

9/1 08-07-15

(x1)

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(1X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. L 08/07/15

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 119

L 8/7/15 (2)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MFC 08-07-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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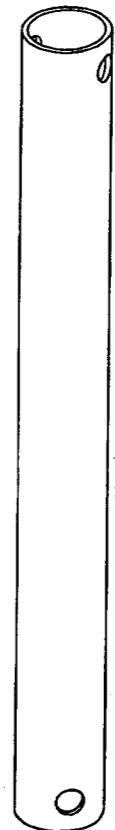
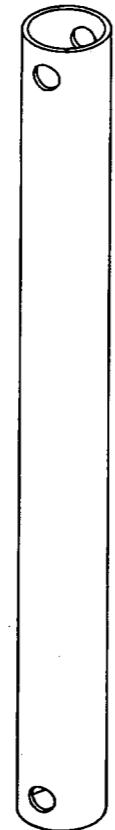
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B

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A

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D3768-1 FRONT INBOARD LEG

D3768-3 FRONT OUTBOARD LEG, LH

D3768-4 FRONT OUTBOARD LEG, RH

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NO. 40312

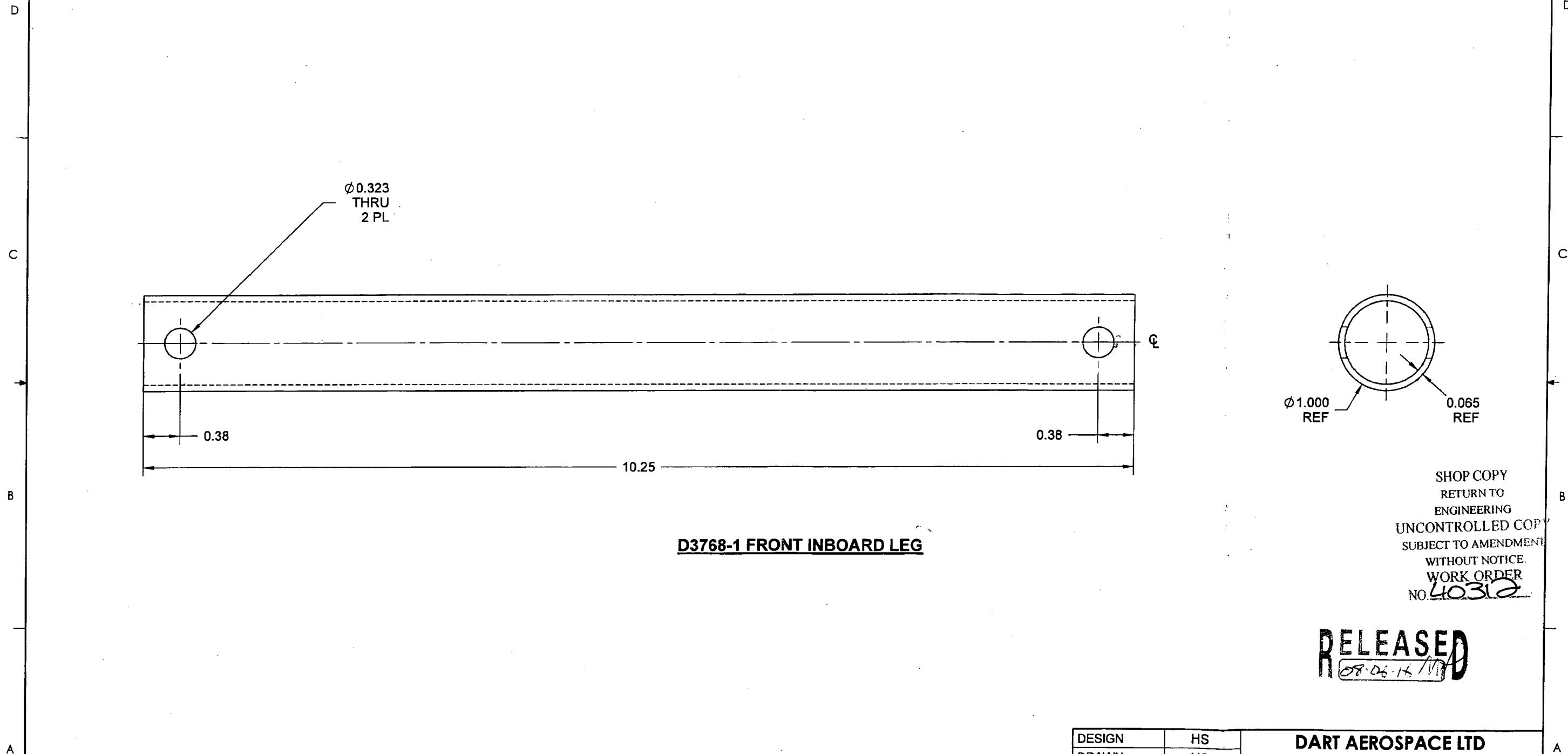
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NOTES:  
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR  
AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.19 lbs

A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b>		
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3768	SHEET 1 OF 4	
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DE APPR.		FRONT LEG	NTS	
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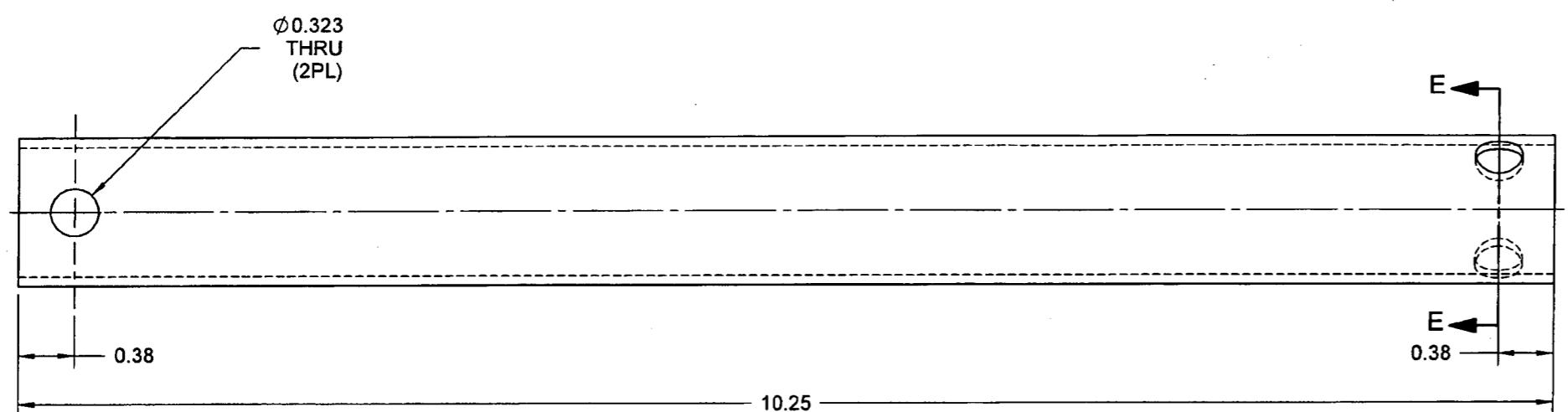
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D3768-3 FRONT OUTBOARD LEG, LH

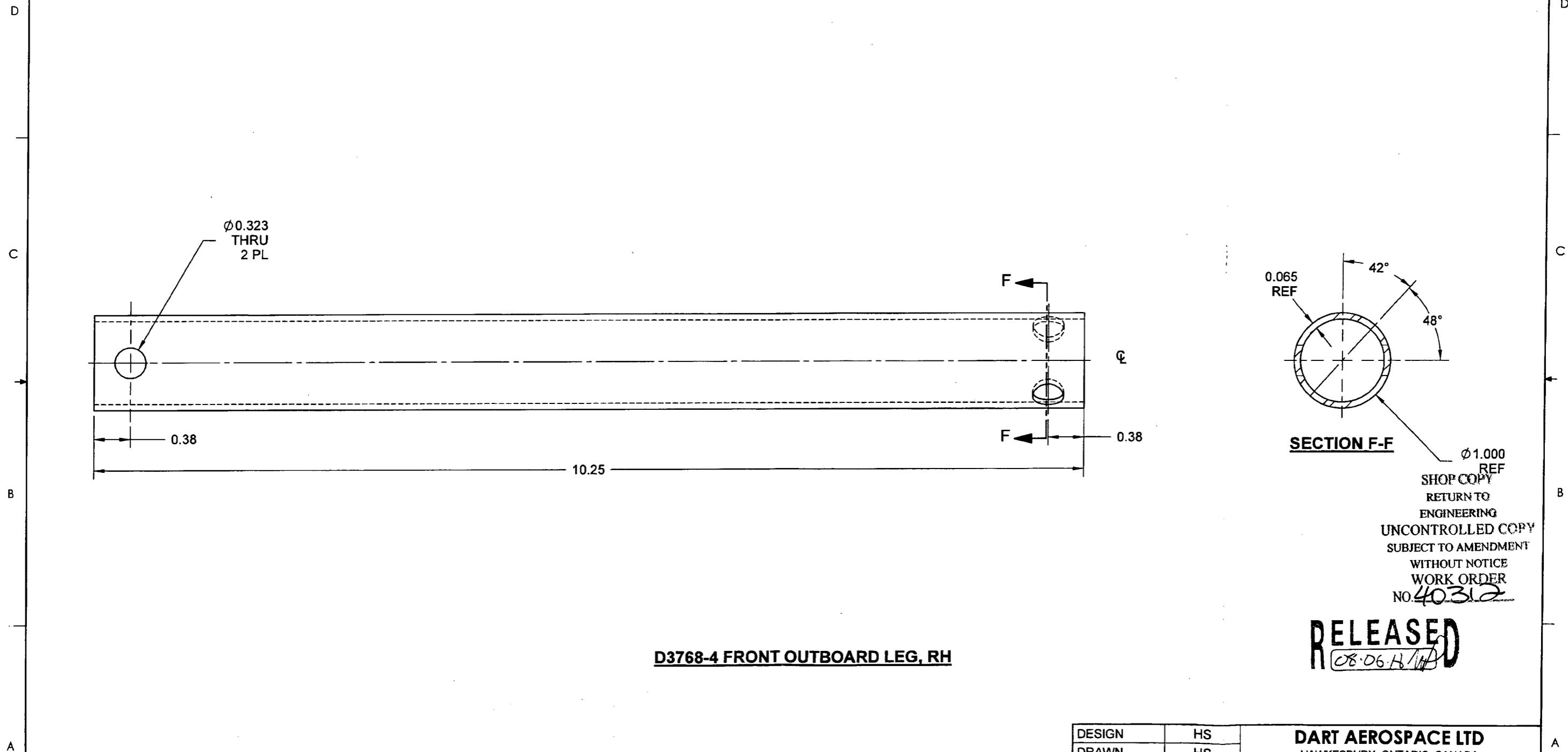
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*08.06.04*

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